

Date: Thursday, 7/20/2006 1:05:39 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY
Job Number : 27991	
Estimate Number : 10257	
P.O. Number : N/A	Part Number : D212664201
This Issue : 7/20/2006 S.O. No. : N/A	Drawing Number : D212-664-241 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 7/20/2006 Type : LANDING GEAR	Drawing Revision : B
Previous Run : 27990	Material : N/A
Written By : <u>KJ 06.07.21</u>	Due Date : 8/30/2006 Qty: 1 Um: Each
Checked & Approved By : <u>KJ 06.07.21</u>	
Comment : Est Rev:E 04.02.16 Reformat K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG002

KJ 06.08.04 (1)

2.0	D6006129	Crosstube material
-----	----------	--------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube 25666

Check OD = 3.250"; ID = 2.220"

MS 06/09/12

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241. MS 06/09/12

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------

**Comment:** INSPECT ALL DIM TO DIM SHEET

MS 06/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:05:39 PM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 27991

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241. *MS 06/09/12*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/09/12

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/09/12

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube

DPG-10-2 done at Sgt# 13

2-Remove sand and plugs *MS 06/10/12*

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

MS 06/10/12

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

M-H 06/10/13

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD

6-10-13

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

DP/EL 07/01/03

W/O:		WORK ORDER CHANGES						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Date: Thursday, 7/20/2006 1:05:40 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27991

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK

QC15



07-01-03 ①



Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

IT 07-01-03

Job 07-01-03

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

Job 07-01-04 ①

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-01-10 ①

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES
Liquid Penetrant Inspection as per QSI 038
Issue P/O: 2846
LPI as per ASTM 1417 Level 2
Attach copy of NDT results to work order

P/O 2891 C207101118 ①
C207101111 ①

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

07/01/15

07/01/15

18.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

07-01-22 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27991

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

M/FC 07 01 22 ①

2-Paint outside crosstube with White Imron as per QSI 005 4.2

M 07 01 22 ①

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

07 01 23 ①

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.8400 f(s)/Unit Total : 0.8400 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-1009 Abrasion Strip

B26650

2T

07-01-23

22.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1

Support

B25594

2T

07-01-23

23.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

M10684

2T

07-01-23

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8582

2-Install supports and clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

2T 07-01-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27991

Part Number: D212664201

Job Number:



Seq. #: Machine Or Operation: Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-1-22

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: *B28018* ✓

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: *M10169.7* ✓

29.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: *M10169.7* *M101418* ✓

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: *M101418* *M101124* ✓

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: *M100151* ✓

CP 04/01/250

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/25

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:05:40 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27991

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

REV: B 7/10/25

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

REV: B 7/10/25

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

7 7/10/25

Job Completion



U 07-0.25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27991
Description: Crosstube Assembly (205/212 High Aft)	Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.990	+0.005/-0.000	2.995	✓			
	5.237	+/-0.030	5.240	✓			
	2.600	+0.005/-0.000	2.604	✓			
	2.686	+0.005/-0.000	2.690	✓			
	2.770	+0.005/-0.000	2.775	✓			
	2.854	+0.005/-0.000	2.858	✓			
	2.938	+0.005/-0.000	2.943	✓			
	3.021	+0.005/-0.000	3.025	✓			
	3.133	+0.005/-0.000	3.137	✓			
	3.179	+0.005/-0.000	3.184	✓			
SIDE B	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.990	+0.005/-0.000	2.994	✓			
	5.237	+/-0.030	5.240	✓			
	2.600	+0.005/-0.000	2.605	✓			
	2.686	+0.005/-0.000	2.690	✓			
	2.770	+0.005/-0.000	2.775	✓			
	2.854	+0.005/-0.000	2.858	✓			
	2.938	+0.005/-0.000	2.942	✓			
	3.021	+0.005/-0.000	3.026	✓			
	3.133	+0.005/-0.000	3.138	✓			
	3.179	+0.005/-0.000	3.184	✓			
	124.36	+/-0.020	124.36	✓			

Measured by: BG / MB	Audited by: J.G	Prototype Approval:	N/A
Date: 06/09/12	Date: 06/09/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D212-664-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.06.09 [Signature]

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

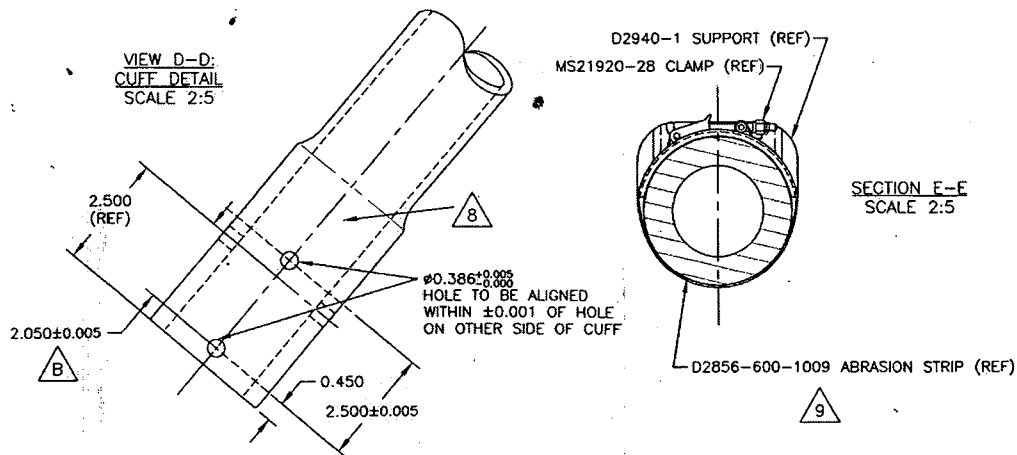
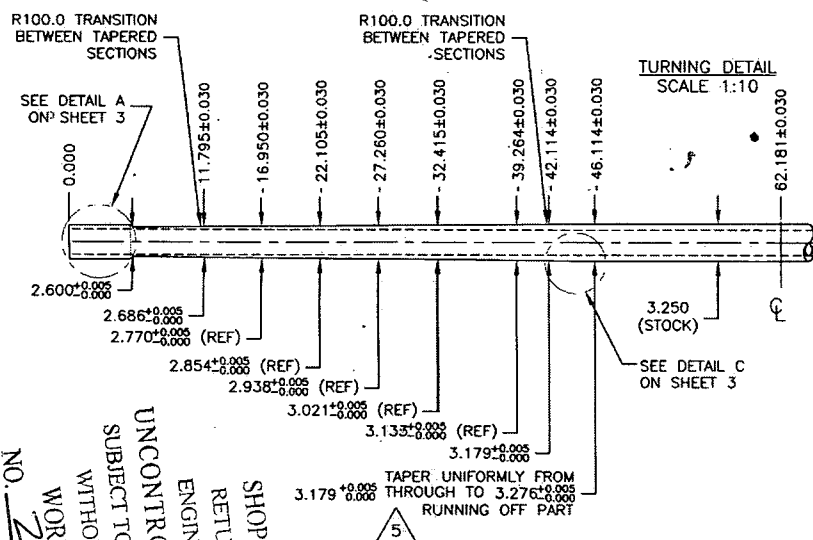
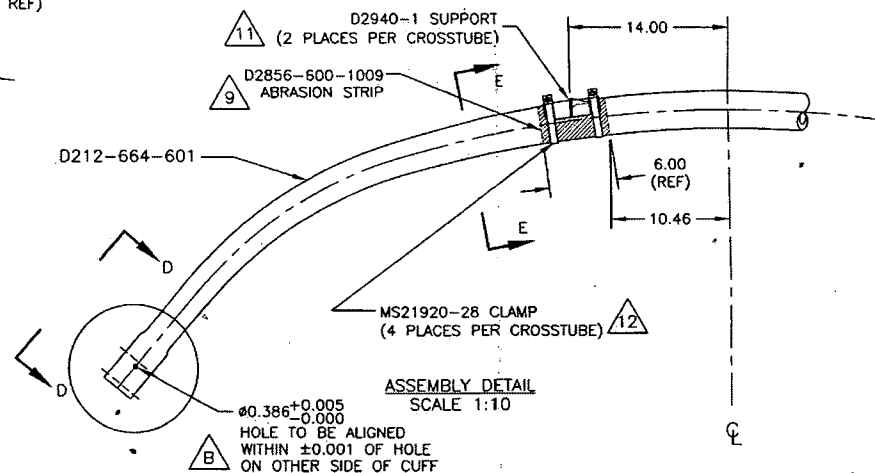
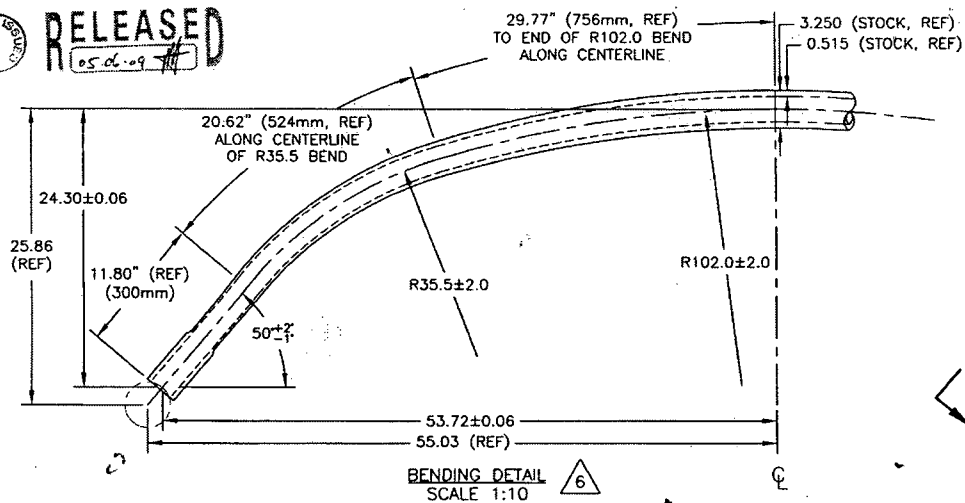
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WITHOUT NOTICE
WORK ORDER
NO. 27991

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05.02.04



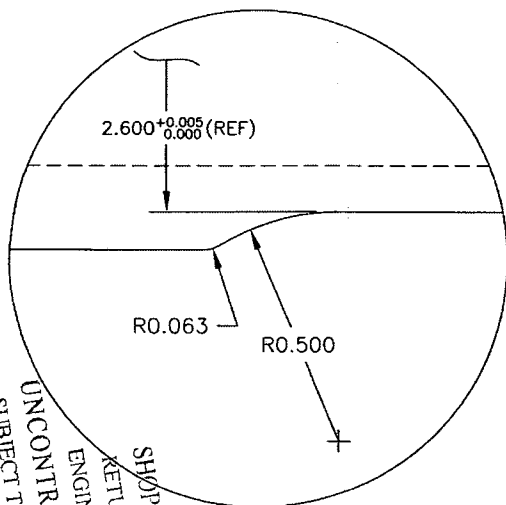
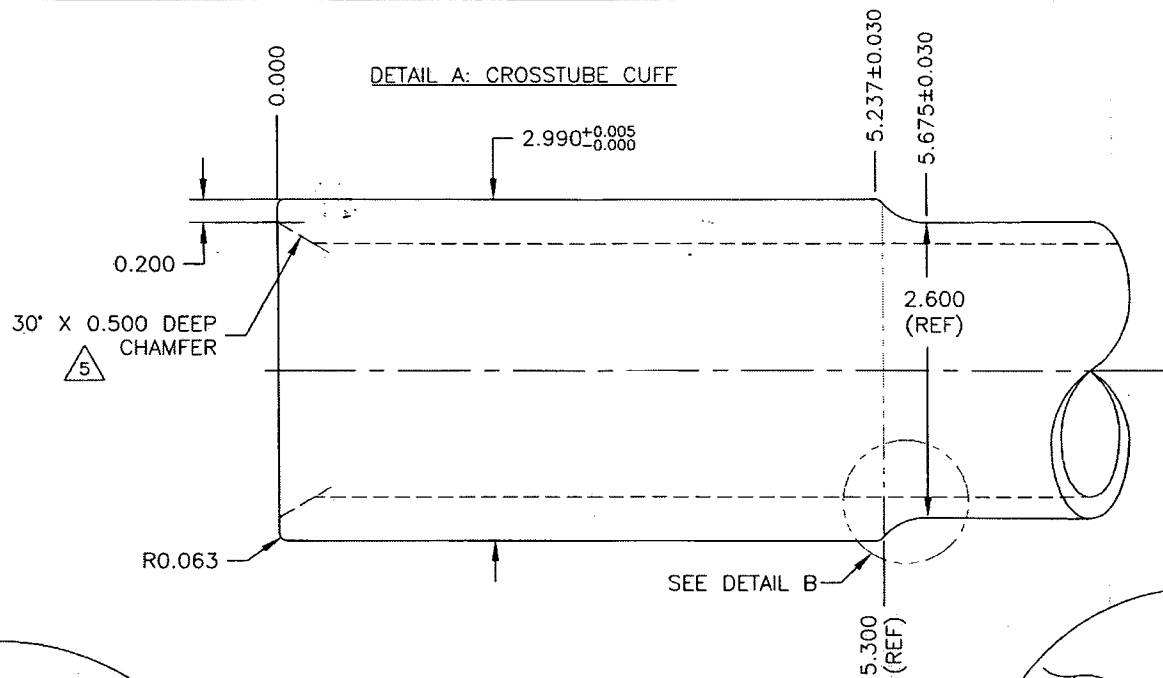
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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. WINDRESSBURT, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D212-664-241	REV. B SHEET 2 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:10

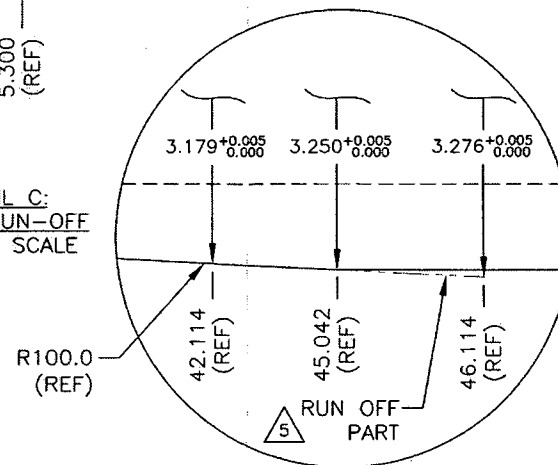
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05-06-09



DETAIL B: CUFF
TRANSITION
SCALE 4:1

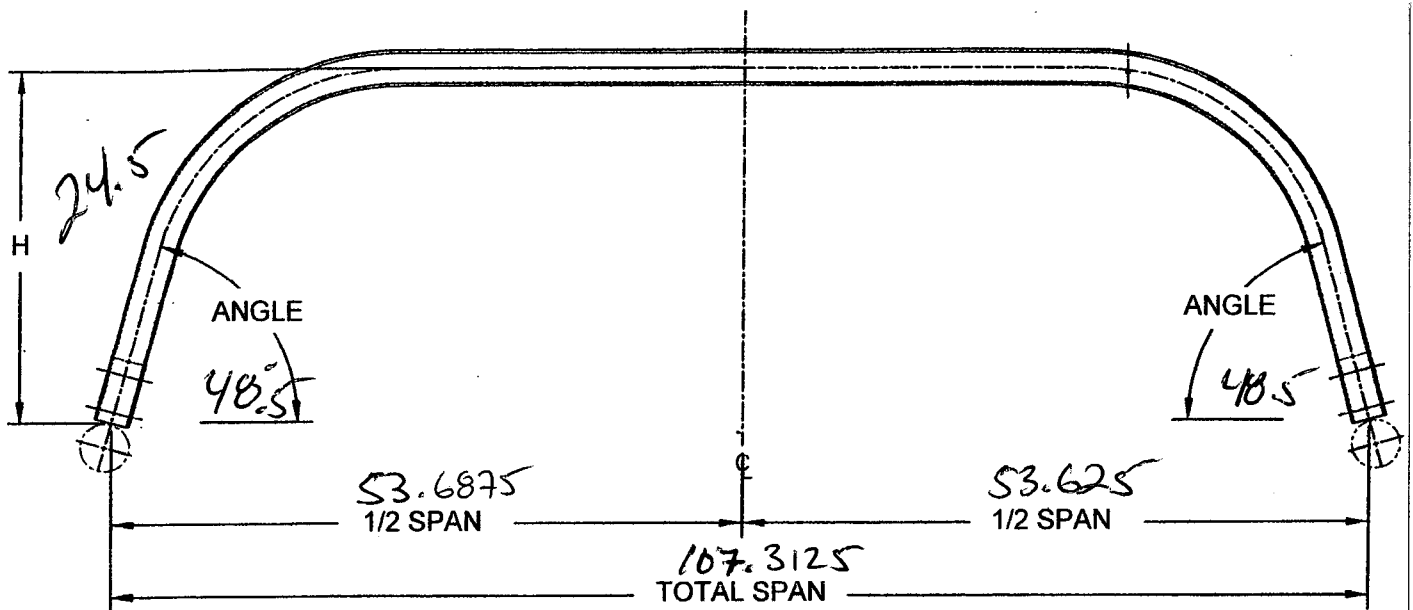
DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)		SCALE 1:1	

Crosstube Bend Dimension Sheet



Fits table guard.

PART NUMBER: D212-664-201

BATCH NUMBER: 27991

DRAWING: 241 REVISION: B

H: 24.30 } $\pm .000$

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50 ± 2

QC 15: *[Signature]*

DATE: 07-01-03

QTY: *[Signature]*



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35529

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (11) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (7) P/N D212-664-101 S/N's B29500, B29505, B29504, B27625, B29501, B27984 & B27986

Qty (4) P/N D212-664-201 S/N's B29509, B27991, B29507 & B28761.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (11) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Four (4) cross tubes (P/N D212-664-201) FAILED inspection. Areas marked on cross tubes (S/N's B29509, B27991, B29507 & B28761). To be reinspected following repair.

Seven (7) cross tubes (P/N D212-664-101) PASSED inspection (S/N's B29500, B29505, B29504, B27625, B29501, B27984 & B27986).

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE January 12, 2007

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER 2846

ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35592

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION: -

MODEL/TYPE: -

SERIAL NUMBER: -

TOTAL HR/LDG: -

OPERATED BY: -

BASED AT: -

INSPECTION REQUIREMENTS

Carry out FPI of (4) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Note: only the rework areas are for reinspection (see previous Work Order # 35529)

Qty (4) P/N D212-664-201 ✓ Cross tubes S/N's B29509, B28761, B29507 and B27991.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (4) Cross Tubes - rework areas only.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(4) cross tubes inspected. (3) PASSED inspection - S/N B29509, B29507 and B27991.
(1) FAILED inspection - S/N B28761.

- photo was given to Jason Murdock
and area was marked on the part.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: _____

DATE January 18, 2007

INSPECTION
STAMP(S) _____

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

ADDRESS: _____

P.O. NUMBER

2891

CONTACT NAME:

Linda

LABOUR	@		\$
MATERIALS	@		
TRAVEL EXPENSES	@		GST
HOTEL EXPENSES	@		PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT